

Date: Thursday, 06/11/2008 3:14:33 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM		
Job Number	: 43250		Part Number	: D2596		
Estimate Number	: 10346		Drawing Number	: D2596 REV D		
P.O. Number	:		Project Number	: N/A		
This Issue	: 06/11/2008 S.O. No. :		Drawing Revision	: D		
Prsh Rev.	: NC		Material	:		
First Issue	: / / Type : SKIDTUBES		Due Date	: 13/11/2008 Qty: 4 Um: Each		
Previous Run	: 43108					
Written By	:					
Checked & Approved By	: <u>JUL 08 11.06</u>					
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M					
	Est Rev:E 07-07-09 Incorporated DEO 9183 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Ext'n -I Beam Web 4"	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4"			
	Pick;		
	Qty Part Number Description Batch		
	1 D2500-3-100 Extrusion <u>40196</u>	<u>SL 8-11-7</u>	
2.0	SKIDTUBES.1	SKIDTUBESS RESOURCE 1	
<b>Comment:</b> LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
<b>Comment:</b> HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

SL 8-11-7

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

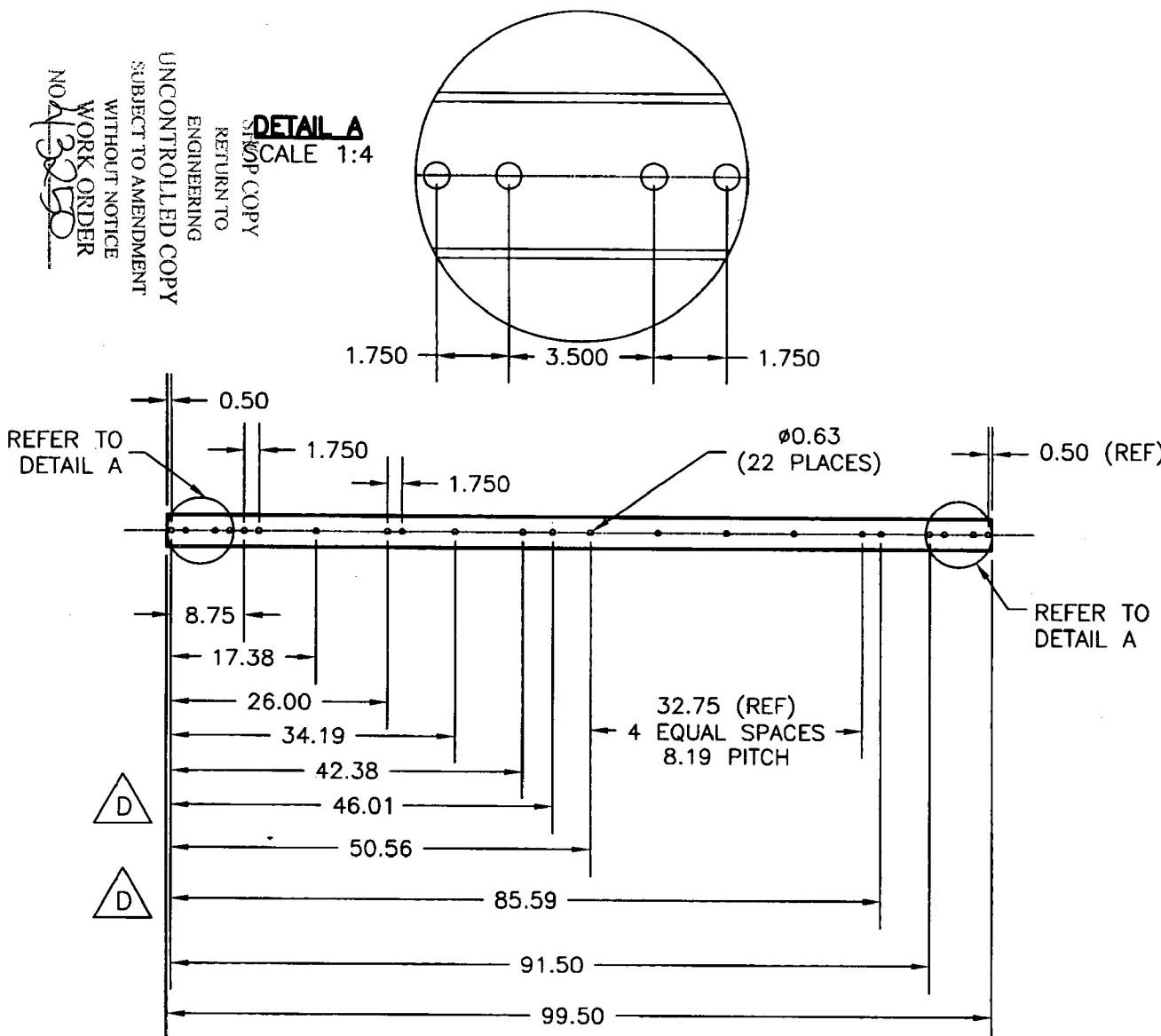
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****RELEASED**  
07.06.08

DESIGN <i>R4</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D2596
DATE 07.04.17	TITLE 205 WEB	REV. D SHEET 1 OF 1
		SCALE 1:20
A <i>M</i>	96.09.16	NEW ISSUE
B <i>M</i>	97.07.23	$\phi 0.63$ HOLE WAS $\phi 0.56$
C <i>M</i>	98.09.14	INCORPORATED DEO 9097
D <i>M</i>	07.04.17	INCORPORATED DEO 9183

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020